

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015298**Date Inspected:** 28-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Shingong.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Subassembly, Bay 09, 13CE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC Personnel performing Fit up for welding Deck panel to U-rib identified as DP3103-001-187. Welders welding tack welds are identified as 062305. Process identified as Gas Metal Arc Welding (GMAW). ZPMC Quality Control Inspector (QC) is identified as Chen Shingong. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U5(U-Rib). The attached photographs provide additional detail.

Subassembly, Bay 09, 13CE, Deck Panel U-ribs.

During Random Visual in process Inspection, this QA inspector observed ZPMC NDT personnel carrying out Ultrasonic Testing (UT) on 33mm Complete penetration joint (CJP) on Continuity Stiffener inside U-Rib. Weld joints identified as DP3106-001-157, 158. The attached photographs provide additional detail.

Subassembly, Bay 09, Gantry# 2, 13BE, Deck Plate to U-rib.

GMAW welding of Partial Penetration weld joints DP3087-001-001 to 008 & 145 to 152; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418, 059378, 203805; ZPMC Quality Control

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Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Subassembly, Bay 09, Gantry# 2, 13BE, Deck Plate to U-rib.

SAW welding of Partial Penetration weld joints DP3087-001-001 to 008 & 145 to 152; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418, 059378, 203805; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Subassembly, Bay 09, Gantry# 2, 13BE, Deck Plate to U-rib.

GMAW welding of Partial Penetration weld joints DP3092-001-001 to 010 & 171 to 180; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418, 059378, 203805; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

Subassembly, Bay 09, Gantry# 2, 13BE, Deck Plate to U-rib.

SAW welding of Partial Penetration weld joints DP3092-001-001 to 010 & 171 to 180; located on Bay 09, Gantry# 2. Welder is identified as 201788, 059416, 059421, 059418, 059378, 203805; ZPMC Quality Control Inspector (QC) is identified as Chen Shi Gang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2342-U1(U-rib)-5.

This QA Inspector carried out NDE on following:

Subassembly, Bay 09, OBG Deck Plate.

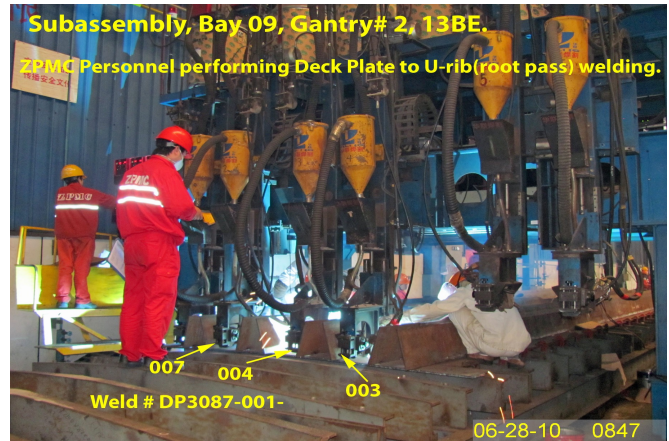
This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 06072). This QA Inspector generated an UT report (TL-6027) for this date. The members are identified as

- 1) DP3106B(PL3202F)-001-165, 166. Complete Penetration joints 33mm long.
- 2) DP3104(PL3200B)-001-174, 175. Complete Penetration joints 33mm long.
- 3) DP3104(PL3200C)-001-236, 237. Complete Penetration joints 33mm long.
- 4) DP3101(PL3197C)-001-271, 272. Complete Penetration joints 33mm long.
- 5) DP3099(PL3195B)-001-155, 156. Complete Penetration joints 33mm long.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
